

Work Order ID 53485



Page 1

November 6, 2009 8:43:03 AM

Item ID: D1049

Accept



Setup Start



Revision ID: A

Stop



Item Name: Saddle

Start Date: 06/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 09/11/09 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D1049	Rev A

100



Shear

~~SHEAR~~ Saw

Shear

Memo

Cut Blanks: 2.000" long

M110829 6x61 T6 .375 x .750

0.00

20

P0

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per folio FA217 & Dwg D1049
2-Deburr

0.00

DTP 09/11/19

20

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

DTP 09/11/19

20

W/O: 53485		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.11.20	100	OK TO USE 6061-T6				CP 09.11.20 PV OK1042	

Part No: D 1049 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53485

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November 6, 2009 8:43:03 AM

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Item Name: Saddle

Start Date: 06/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

SF 09/11/19



QC

Memo

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

all 09/11/23



HandFinish

Memo

Hand Finishing

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M 10/09/11



Powdercoat

Powder Coating

Memo

START TIME: 8:45

OVEN TEMPERATURE: 320°

FINISH TIME: 9:15

0.00

floor out. 20

Work Order ID 53485

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November 6, 2009 8:43:03 AM

Item ID: D1049

Accept



Setup Start



Revision ID: A

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Item Name: Saddle

Start Date: 06/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

0.00

=7 M-f 09/11/24

170

Identify as per dwg & Stock Location: 2

0.00

Packaging

Memo

0.00

9/11/24 200 SP

Quality Control

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/11/25 SP

PL 09-11-24
(20)

Picklist Print

Page 1

November 6, 2009 8:43:07 AM

Work Order ID: 53485



Parent Item: D1049RevA



Parent Item Name: Saddle

Start Date: 06/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T5.000W.125		Purchased	No			f		20.7400	7.5200			

6061-T6 Tube 5.00 X 125W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	20.74	
102019	5.24	
105532	3.5	
111699	12	

N/A
Dury At.
Sec 11/10
JW 09/11/19
6061T6 375x.75M110829

3.33(F)

DTP 09/11/19

DART AEROSPACE LTD	Work Order:	534185
Description: Saddle	Part Number:	D1049
Inspection Dwg: D1049	Rev: --	Page 1 of 1

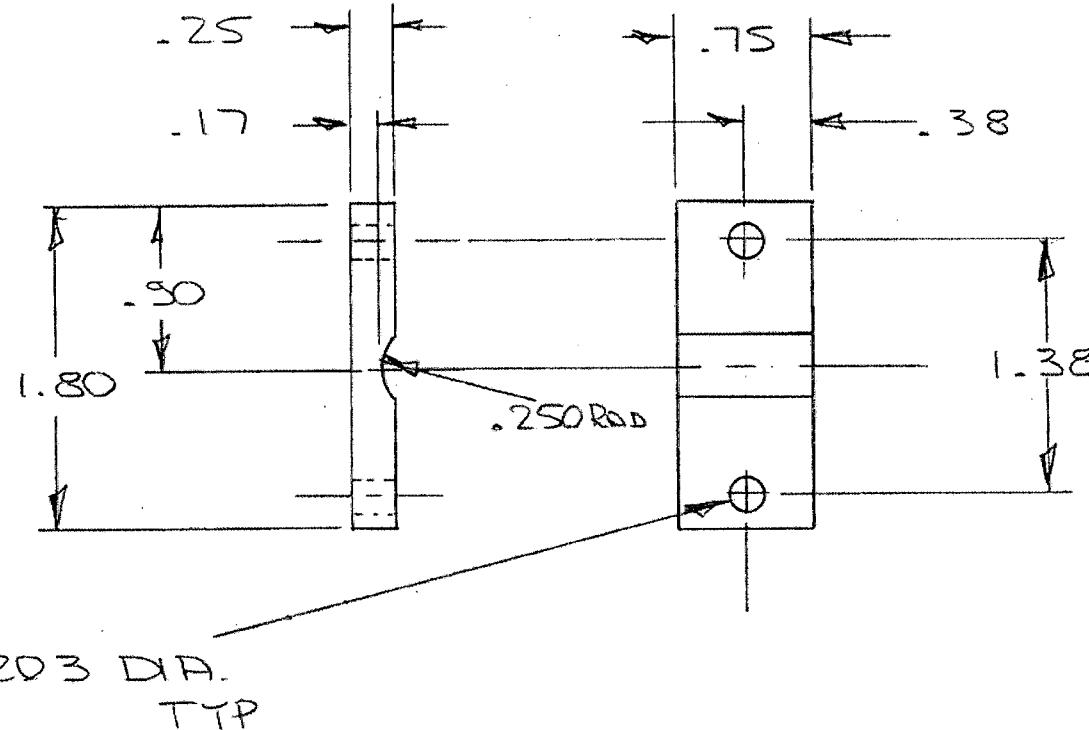
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/11/19	Date:	09/11/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	TT

RELEASED
97/09/02 BW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WILCOX & CO.
WORK ORDER

Bl 09-11-6

MATERIAL : SOSZ-H32
OR 6061-T6 Dated 11.20

FINISH: POWDER COAT

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN			BASIC CODE	O/A, DASH NO. N=HEAD NEAR SIDE F=HEAD FAR SIDE	CONTRACT NO.				DART AERO ACCESSORIES INC. VANCOUVER CANADA
APPROVED			D=DRAPE DGT=NO. OF SHEETS C=COUNTERSINK	LENGTH DASH NO. W=SPOTWELD	DRAWN	DATE			
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED	GENERAL	LIMITS						
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS $\text{RA} \leq .010$ 3. REMOVE DRAFT EDGES $\leq .015$ MAX 4. TOLERANCE PER MIL = $.8 - .004$ 5. HOLES PER INCH $\leq .007$	1. TOLERANCES — $\pm .000$ $\pm .001$ 2. ANGLES $\pm 1^\circ$ 3. PARALLELISM $\pm .0075$ 4. ECCENTRICITY $.005$ MAX 5. SURFACE FINISH ABOUT ALL M/C CENTRE LINES $.005$		BASIC CODES 8J=M52047040 8B=M52042840	STRESS				
					CHECKED				
					CLIENT				
	REPORT ALL DISCREPANCIES — DO NOT SCALE				CODE	DMG NO			
					SCANT	1 : 1	SHT	1	REV

Date: Tuesday, 17/02/2009 10:18:10 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE BLOCK		
Job Number	: 45810					
Estimate Number	: 10324					
P.O. Number	:			Part Number	: D1049	
This Issue	: 17/02/2009		S.O. No. :	Drawing Number	: D1049 REV A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: A	
Previous Run	: 39919			Material	:	
Written By	:			Due Date	: 03/03/2009	
Checked & Approved By	<u>JUL 09-02-17</u>			Qty:	20	Um: Each
Comment	: Est RevC 02.04.10 Re-format NG			REFERENCE ONLY		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0750X00250	6061-T6 Bar .750 x .250	
		<i>30.375 x .750 M18237 X 16 parts</i>	
Comment: Qty.: 0.1749 f(s)/Unit Total : 3.4986 f(s) Material: 6061-T6 bar .750 wide x .250 thick. Batch <u>M110829 375X.750X4parts</u>			<i>88 09/02/19</i>
2.0	SHEAR	SHEAR	
Comment: SHEAR Cut Blanks: 2.000" long			<i>88 09/02/19</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1			
	1-Machine as per folio FA217 & Dwg D1049		
2-Deburr			<i>ok 09/02/25</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			<i>ok 09/02/25</i>
5.0	QC8	SECOND CHECK	
Comment: SECOND CHECK			<i>ok 09/02/25</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		-154792						

NOTE: Date & initial all entries